



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3490-1
Job Sheet 175661



Part No: D3490-1

Job Qty: 120 ea

Part Name: Cross Bolt Spacer



124

DAS
21
9-89

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea		4/20/18	0.00	0.00	Start Up Machining-2	mm	JB - 18-04-26
100	Hardinge	120 pcs		4/23/18	0.00	9.76	Hardinge	11	JB - 18-04-26
120	QC	120 pcs		4/23/18	0.00	0.00	QC8		21 18/04/28
130	Packaging	120 pcs		4/23/18	0.00	0.00	Packaging3-1		BE
140	QC21-SA	120 Ea		4/23/18	0.00	0.00	QC21		21 APR 30 2018

Part Op 100 - 1-TURN AS PER FOLIO FA628 & DWG D3490

Descriptions: 130 - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.049	6061-T6 Round Tube .500 X.049W	31.9200 ft (.266 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.049	32	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	0.500inches	+ 0.006 - 0.001	0.506 0.499	
2	Crossbolt Spacer	0.049inches	± 0.010	0.059 0.039	
3	Crossbolt Spacer	0.402inches	+ 0.006 - 0.001	0.408 0.401	
4	Crossbolt Spacer	3.085inches	+ 0.030 - 0.000	3.115 3.085	
5	Crossbolt Spacer	0.050inches	± 0.010	0.060 0.040	
6	Crossbolt Spacer	45Degrees	± 0	45 45	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description V	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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DART
 AEROSPACE

Container No: S065863
 Part: D3490-1
 Job No: 175661
 Serial No/Batch: S065863
 Revision:
 Inspector:

Date: 04/28/18

Root Cause			
Environment	☐	No Re-ver	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

/Surge
am

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence